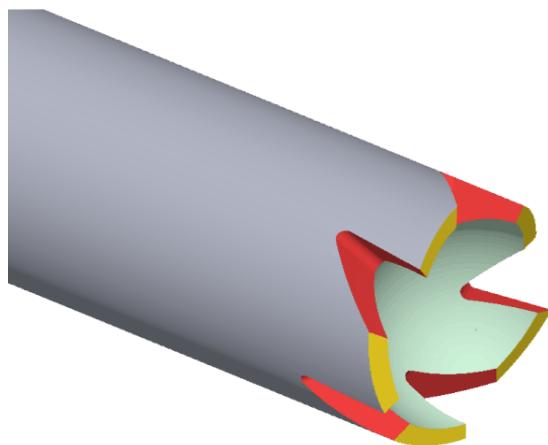


# Injection Needle Cutting Tip Ø2.35

A26-400

In order to keep a minimal sharpness of the gashing wheel as well as a good surface finish and avoid burrs, the operations are ground by oscillations. The corindon wheels can be periodically reshaped on a dressing unit.



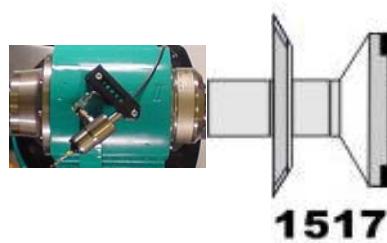
## 1. Cycletime for Production

Tool specifications			
Diameter 2.35 mm, Z 5, Gash angle 30°			
Material INOX			
Operations			
Probe		Gashing	End 1
Feed [mm/Min]	2000	500	500
Power [kW]		2	1
Cutting feed [m/s]		32	24
Used wheels			
Grinding time [s]	11	49	58
Total cycle time	1 Min 57		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

15 Ø125 1V1 C500  
17 Ø125 12A2 C500



## 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG, Dressing Unit  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3

responsible engineer:

[www.schneeberger.ch](http://www.schneeberger.ch)

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